

Work Order ID 68003

Tuesday, April 05, 2011 10:50:06 AM



Page 1

Item ID: D4380-31

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cover, Post Oxygen Panel

Start Date: 4/5/2011 Start Qty: 2.00



Required Date: 4/5/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

~~PRELIMINARY ISSUE~~

[Handwritten signature]

Reference:

Run Start



Approvals: Process Plan: MF Date: 11-04-05 Tooling:

Date:

Stop



QC: Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4380

240 PAT - 02 11/04/05

[Handwritten signature]

0.00

100



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2

BB
11/04/05

105



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: 150°C

Time IN: 6:00pm 11/04/04

Time OUT: 7:00pm 11/04/05

2

BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA125 using tool DT9750 Dwg Rev: <u>PA-7</u> Folio Rev: <u>A</u>	0.00				2			BB 11/04/05
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00				2			BB 11/04/05
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				2			BB 11/04/05

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Required Date: 4/5/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

2

DL
11/04/05

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

2

DL
11/04/05

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

inspector to P42

Dry only

Subtotal

(R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 4/5/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: *RDG*

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

0.00

RD2370

POSITIVE RECALL

EFFECTIVE *11/05/13*

AUTH *MF*

RELEASED *MF*

DATE *11/05/13*

11-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:50:04 AM

Page 1

Work Order ID: 68003



Parent Item: D4380-31



Parent Item Name: Cover, Post Oxygen Panel

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Rev. A New Issue 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	6.9375			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

787.2912

Loc Code

116576

6.9375 sg OK

DL
11/04/04

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DART AEROSPACE LTD	Work Order: 68003
Description:	Part Number: D4380-31
Inspection Dwg: D4380 Rev: PAT	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: She

Date: 11/04/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.0"	±0.100"	3.0"	✓		✓ th-01	
1.5"	±0.100"	1.5"	✓		✓	
N/A 0.75"	±0.030"	0.745"	✓		✓	

Measured by: She

Date: 11/04/05

Audited by: 8 PAT Dmy only

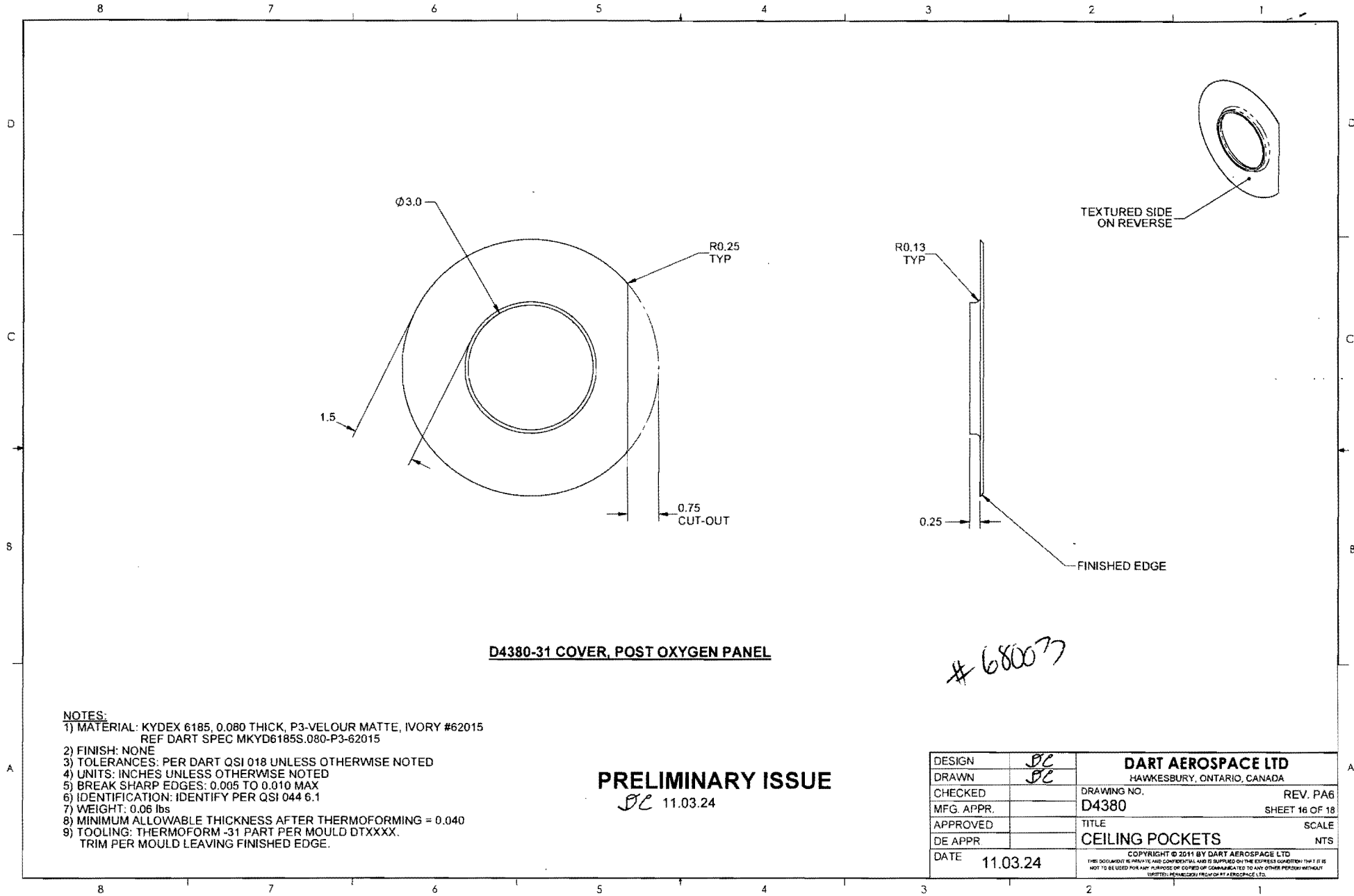
Date: 11/04/06

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-31 COVER, POST OXYGEN PANEL

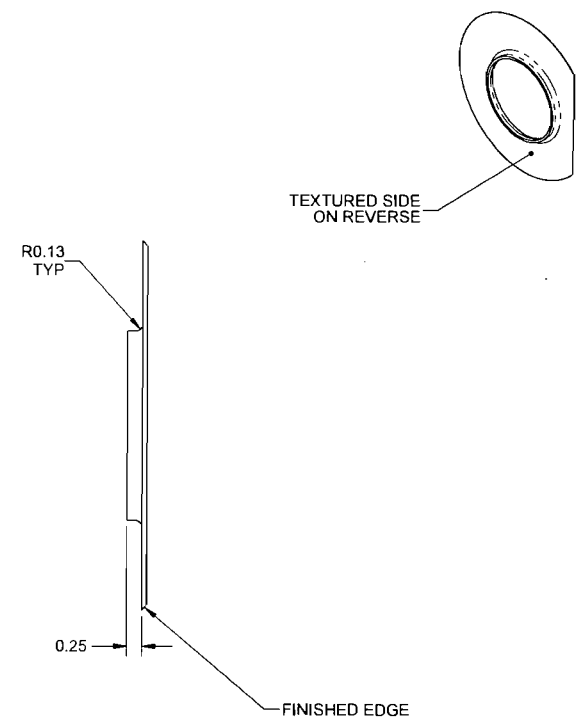
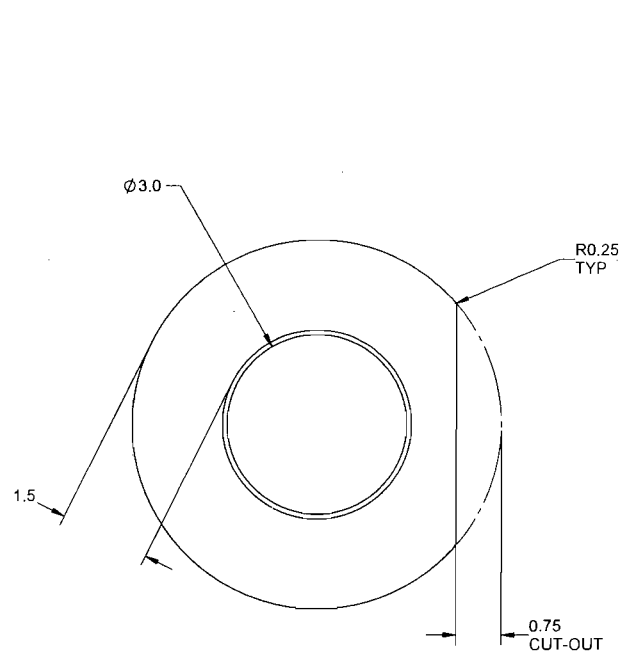
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NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -31 PART PER MOULD DTXXXX.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE
DL 11.03.24

DESIGN	DL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DL		
CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		D4380	SHEET 16 OF 18
APPROVED		TITLE	SCALE
DE APPR		CEILING POCKETS	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4380-31 COVER, POST OXYGEN PANEL

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -31 PART PER MOULD DT9750.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE
BC 11.04.05

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 16 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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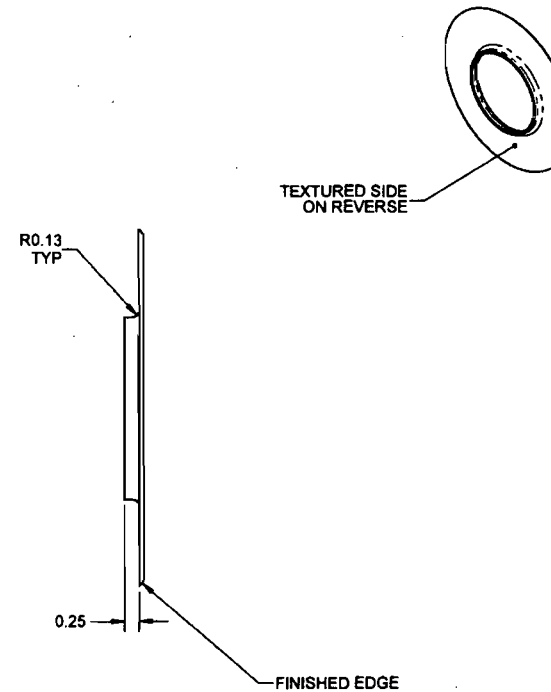
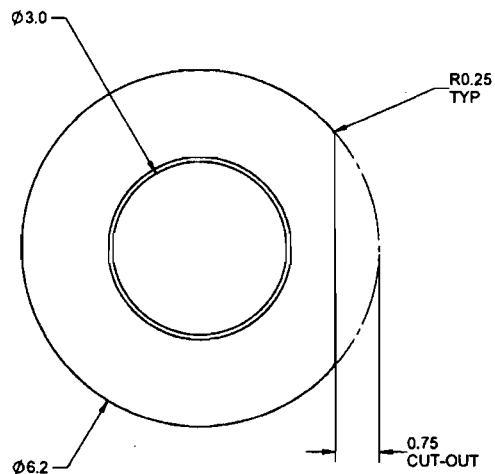
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4380-31 COVER, POST OXYGEN PANEL

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.09 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9750 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE

RELEASED
2011-05-11

68003

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 16 OF 19
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
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